

Order ID 70588

ay, June 13, 2011 11:21:35 AM



Page 1

Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D412-630 bluefile &amp; type labels per PPP412-630-031 CHG003

CK for CL 11/07/07

110

0.00



Small Fab

Small Fab

Small Fab

Memo

0.00

Assemble as per dwg D412-630 p.17

\*\*\*\*ensure tension to retract step is 11 to 18 lbs before installing lockwire.\*\*\*\*

EFS 11/07/08 (1)

120

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

\*\*\*\*ensure tension to retract step is 11 to 18 lbs \*\*\*\*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70588**

Monday, June 13, 2011 11:21:35 AM



Page 2

Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/7 SP

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/11/10/10

76  
LH

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-031

Location: \_\_\_\_\_

PPP Rev: D

11/7/8 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 70588**

Monday, June 13, 2011 11:21:35 AM

Page 3

Item ID: D412-630-031

Accept

Setup Start

Revision ID:

Stop

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011 Start Qty: 1.00

Required Date: 6/22/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/07/08

mf

11-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 13, 2011 11:21:43 AM

Page 1

Work Order ID: 70588

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)


Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC  
IPP REV. B 05.12.19 updated pick list EC  
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			130	Each	35.0000	1	1			

Location Loc Qty Loc Code

ST324

35

117795

15

117872

20

AN310-5  
  
NUT

Purchased No

130

Each

20.0000

2


Location Loc Qty Loc Code

ST324

20

114830

20

AN3C5A  
  
Bolt

Purchased No

130

Each

1,757.000

3

Location Loc Qty Loc Code

FP-A

7

115835

7

ST350

1750

116419

96

116549

54

117343

500

117508

300

117764

300

117872

500

7

1180785

2

2  
3  
11/7/85

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Page 2

Work Order ID: 70588

Parent Item: D412-630-031


Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011


Start Qty: 1.00

Required Qty: 1.00

AN44-C12 Purchased No 130 Each 23.0000 1  *SP*


eyebolt

Location	Loc Qty	Loc Code
ST362	23	
114669	3	
117616	20	

AN4C15 Purchased No 130 Each 15.0000 1  *SP*


BOLT

Location	Loc Qty	Loc Code
ST358	15	
117764	15	

AN5C11 Purchased No 130 Each 33.0000 1  *SP*


BOLT

Location	Loc Qty	Loc Code
ST337	33	
113950	3	
114801	30	

AN5C15 Purchased No 130 Each 27.0000 1  *SP*

BOLT

Location	Loc Qty	Loc Code
ST338	27	
114669	7	
117616	20	

AN960C10 NAS1149C0363 Purchased No 130 Each 0.0000 7  *11147412 11/2/8 SP*

WASHER

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Page 3

Work Order ID: 70588

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C516

Purchased

No

130

Each

39.0000

1

1



WASHER

Location

Loc Qty

Loc Code

ST347

39

102842

39

D3454-1

Manufactured

No

130

Each

20.0000

1



Bushing

Location

Loc Qty

Loc Code

ST054

20

58555

20

D3454-3

Manufactured

No

130

Each

10.0000

2



Bushing

Location

Loc Qty

Loc Code

ST058

10

56420

10

D3454-5

Manufactured

No

130

Each

12.0000

2



Bushing

Location

Loc Qty

Loc Code

ST054

12

68468

12

D3455-1

Manufactured

No

130

Each

7.0000

4

4



Spacer

Location

Loc Qty

Loc Code

ST054

7

68469

7

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 70588

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3455-3

Manufactured No

130

Each

21.0000

2

Spacer

Location

Loc Qty

Loc Code

ST054

21

68470

21

D3462-041

Manufactured No

130

Each

0.0000

1

Bracket Assembly

MS21043-3

Purchased No

130

Each

353.0000

3

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

273

112314

273

MS24665-227

Purchased No

130

Each

28.0000

2

COTTER PIN

Location

Loc Qty

Loc Code

ST309

28

113845

28

MS24665-229

Purchased No

130

Each

123.0000

2

COTTER PIN

Location

Loc Qty

Loc Code

ST309

123

111041

123

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Page 5

Work Order ID: 70588

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H5

Purchased No

130

Each

123.0000

1

1



Washer



sl 11/7/18

## Location

## Loc Qty

## Loc Code

FG

40

103286

20

103691

20

ST277

83

109430

83

D3463-041

Manufactured No

110

Each

0.0000

1



Step Weldment Assembly

B70532 (1K)



EP 11/07/08

D3443-043

Manufactured No

110

Each

0.0000

1



Strut Weldment Assembly

B69945 (1K)



EP 11/07/08

D3443-041

Manufactured No

110

Each

0.0000

1



Strut Weldment Assembly

B70524 (1K)



EP 11/07/08

D3443-9

Manufactured No

110

Each

4.0000

2



Pin



EP 11/07/07

B70526 (2K)

## Location

## Loc Qty

## Loc Code

ST053

4

68475

4

D3454-7

Manufactured No

110

Each

2.0000

2



Bushing



EP 11/07/07

B70528 (2K)

## Location

## Loc Qty

## Loc Code

ST054

2

59256

2

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

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Page 6

Work Order ID: 70588

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3455-1  
Spacer

Manufactured No

110 Each

7.0000

2

2

Location

Loc Qty

Loc Code

ST054

7

68469

7

110 Each

18.0000

1

1

D3465-1  
Washer

Manufactured No

Location

Loc Qty

Loc Code

ST054

18

46134

18

110 Each

21.0000

2

2

AN4CH3  
SS Bolt

Purchased No

Location

Loc Qty

Loc Code

ST355

1

114801

1

ST357

20

117616

20

110 Each

39.0000

1

1

AN4C14  
BOLT

Purchased No

Location

Loc Qty

Loc Code

ST357

25

117688

25

ST358

14

114669

14

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Monday, June 13, 2011 11:21:45 AM

Page 7

Work Order ID: 70588

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN310-4

Purchased

No

110

Each

35.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST324

35

117795

15

117872

20

AN310-7

Purchased

No

110

Each

41.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST324

41

114784

41

MS24665-227

Purchased

No

110

Each

28.0000

1

1



COTTER PIN

Location

Loc Qty

Loc Code

ST309

28

113845

28

MS24665-302

Purchased

No

110

Each

204.0000

1

1



Cotter Pin

Location

Loc Qty

Loc Code

ST309

4

113644

4

ST357

200

117460

200

EP 11/07/07  
M118078 (2)

EP 11/07/07

EP 11/07/07  
M111041 (PK)

EP 11/07/07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

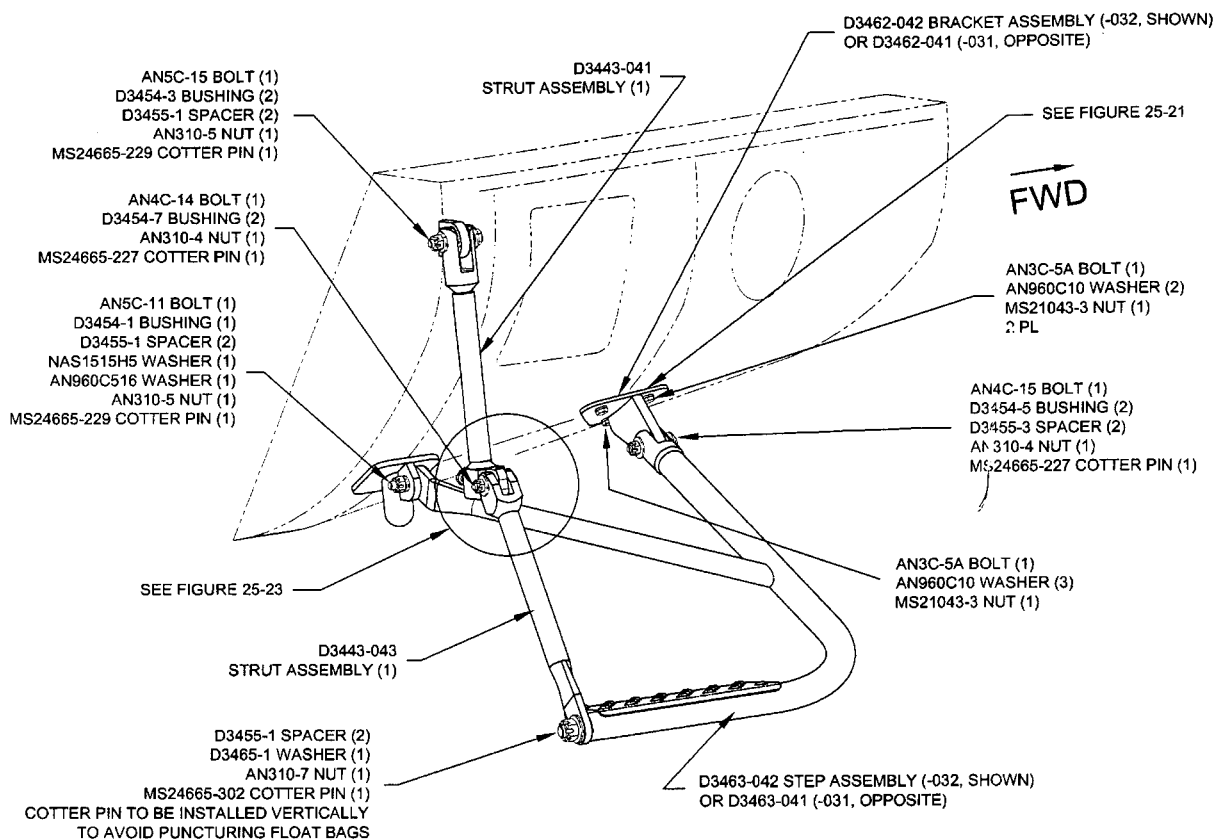


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)

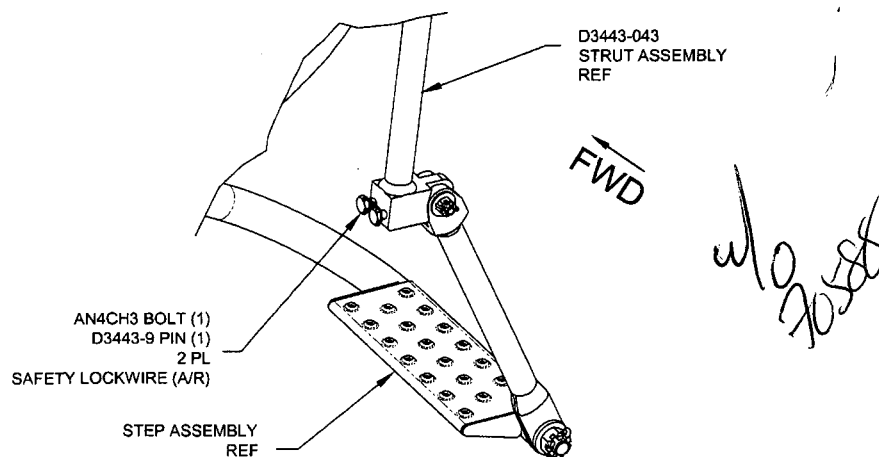


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)

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25-00-00

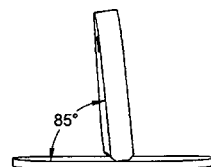
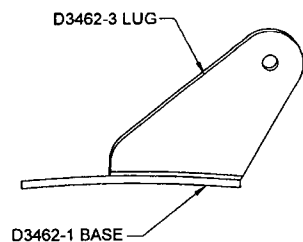
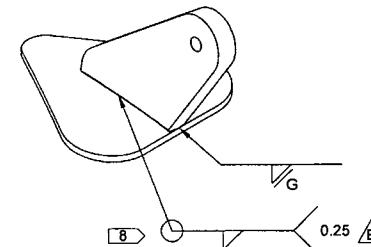
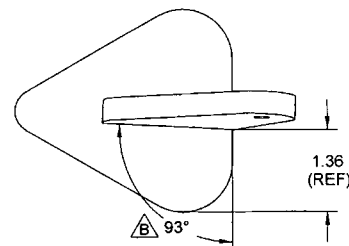
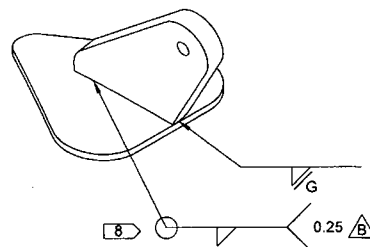
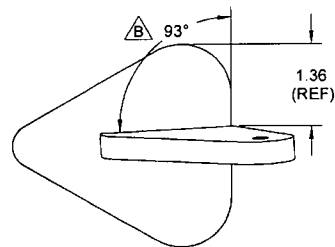
Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
<del>1</del>	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
<del>1</del>	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
<del>1</del>	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

\* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034<sup>TM</sup> HELI-ACCESS-STEP

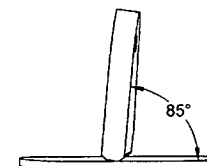
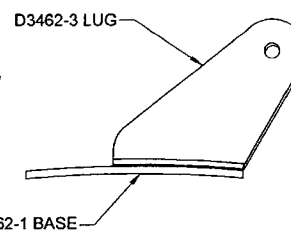
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Revision: **M**  
Date: 08.12.12



**REFERENCE ONLY**



**D3462-041 BRACKET ASSEMBLY**

**D3462-042 BRACKET ASSEMBLY**

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN	1/1/05 DC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3462	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	1:2
DATE	07.10.24	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	